



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

06/993

648.4702
Job Sheet 172861

Part No: 648.4702

Job Qty: 1 ea

Part Name: C3 Overhaul



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/22/18

Job Tracking No:

Due Date: 3/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: O&OPM-C3 REV.4 IPP REV:A 17.12.11 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/8/18	0.00	0.00	Start Up Stores/Pkg-1		<i>SB</i>
110	Small Fab	1 pcs		3/9/18	0.00	1.00	Small Fab-9		<i>SB</i> <i>DAS</i>
120	QC	1 pcs		3/9/18	0.00	0.00	QC4		<i>38</i>
125	DC	1 pcs		3/9/18	0.00	0.00	DC		<i>9-88</i>
130	Packaging	1 pcs		3/9/18	0.00	0.00	Packaging3-1		<i>Smb</i>
140	QC21-FG	1 Ea		3/9/18	0.00	0.00	QC21		

Part Op 110 - Pick kit

Descriptions: 125 - Photocopy bluefile & type labels per PPP 648.7402

130 - Identify and pack for shipping as per PPP 648.4702

DAS
21
9-88
APR 04 2018
fs 102

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-1032-1/4 +	Set Screw	2 Ea (2 ea)	90-Start up Operation	<i>5010651</i>
188-FSCS-832-5/8 +	Clock Spring Cover Screw	4 Ea (4 ea)	90-Start up Operation	<i>5038399</i>
600.1309-A +	Label	1 Ea (1 ea)	90-Start up Operation	<i>5028592</i>
600.1313 +	C3 Warning Label	1 Ea (1 ea)	90-Start up Operation	<i>5029483</i>
AN4-16A - <i>57343</i> +	Bolt	3 Ea (3 ea)	90-Start up Operation	<i>5014150</i>
C2-14-2 +	Label Rivets	2 Ea (2 ea)	90-Start up Operation	<i>OK 504066 + 502724</i>
C2-3-1 +	Bearing DU	2 (2 ea)	90-Start up Operation	<i>5029243</i>
C2-3-2-1	Roller Pin Retaining Ring	2 (2 ea)	90-Start up Operation	<i>5039247</i>
C2-3-3-1 +	Latch Roller DU Bearing	1 Ea (1 ea)	90-Start up Operation	<i>5050472</i>
C2-3-5 +	Spacer, Teflon	2 (2 ea)	90-Start up Operation	<i>5029249</i>
C2-3-8 +	Actuator Bushing	2 Ea (2 ea)	90-Start up Operation	<i>5046985</i>
C3-10-2 +	Lock Spring	1 Ea (1 ea)	90-Start up Operation	<i>5029262</i>
C3-12-1 +	Lock Bushing	2 Ea (2 ea)	90-Start up Operation	<i>5035073</i>
C3-12-6 (5100-0037-SPP) +	Lock Roller Retaining Ring	2 (2 ea)	90-Start up Operation	<i>5029269</i>
C3-13-1 (06FDU04) +	Keeper DU-Bearing Bushing	2 (2 ea)	90-Start up Operation	<i>5029270</i>
C3-13-5 (DENDOFF) +	Keeper Spring	1 (1 ea)	90-Start up Operation	<i>5029273</i>
C3-3-4-1 (5100-0012-SPP) +	Retaining Ring	4 (4 ea)	90-Start up Operation	<i>5041607</i>
C3-3-9 +	Actuator Spring	1 (1 ea)	90-Start up Operation	<i>5029280</i>
C3-4-1 +	Load Beam Bushing	2 Ea (2 ea)	90-Start up Operation	<i>5029281</i>
C3-7-1 +	Load Beam Bumper	1 Ea (1 ea)	90-Start up Operation	<i>5029283</i>
C3-7-2 +	Lock Bumper	2 Ea (2 ea)	90-Start up Operation	<i>5029284</i>
C3-8-4 +	Solenoid Cover Gasket	1 (1 ea)	90-Start up Operation	<i>5029287</i>

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Re-iss ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																														
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																															
Large Fab ☐	Composite ☐	Supplier ☐																																																																
Date : _____		MRB (QSI042) Approval _____																																																																
Description: _____ Dart Aerospace Ltd. 1270 Aberdeen Street Newmarket, ON K6A 1K7 CANADA TEL: 1 513 832-5200 Email: sales@dartaero.com www.dartaerospace.com DART AEROSPACE Container No: S058073 Part: 648.4702 Job No: 172861 Serial No/Batch: S058073 Revision: 4 Inspector: _____ Date: 04/04/18		Completed By _____																																																																
		Lead hand / Supervisor Approval Verification _____																																																																
		QC / QA Coordinator Approval _____																																																																
<table style="width:100%; font-size: x-small;"> <tr> <td colspan="2">Root Cause</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Environment ☐</td> <td>No new</td> <td></td> <td></td> <td>Power Loss/Surge ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Benches ☐</td> <td></td> <td>olio/Program ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Centre Not Concentric ☐</td> <td></td> <td>Grain ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> <td>Broken/Damaged ☐</td> <td>Weld ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> <td>Countersink ☐</td> <td>Off-set ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td colspan="3" rowspan="2">OTHER : _____</td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> </tr> </table>					Root Cause					Environment ☐	No new			Power Loss/Surge ☐	Design ☐	Operator ☐	Benches ☐		olio/Program ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐		Grain ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damaged ☐	Weld ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			Misidentified ☐	Past Due ☐
Root Cause																																																																		
Environment ☐	No new			Power Loss/Surge ☐																																																														
Design ☐	Operator ☐	Benches ☐		olio/Program ☐																																																														
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐		Grain ☐																																																														
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damaged ☐	Weld ☐																																																														
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐																																																														
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐																																																														
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐																																																														
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐																																																														
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐																																																														
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐																																																														
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																																																																
Misidentified ☐	Past Due ☐																																																																	

NAS1149F0463P 5T262+	Washer	8 Ea (8 ea)	90-Start up Operation	FM127832-25
MS21044N4 5T304+	Nut, Self-Locking	4 Ea (4 ea)	90-Start up Operation	FM136648-30
AN4-17A 343+	Bolt	1 Ea (1 ea)	90-Start up Operation	5027724
MS21083N3 298+	Nut	2 Ea (2 ea)	90-Start up Operation	5036469
NAS1149F0332P 262+	Washer	2 Ea (2 ea)	90-Start up Operation	5013478
MS35266-63 270+	Solenoid Cover Screw	1 Ea (1 ea)	90-Start up Operation	5038767
NAS1149F0363P 262+	Washer	1 Ea (1 ea)	90-Start up Operation	5022597
AN6-15A 334+	Bolt	1 Ea (1 ea)	90-Start up Operation	5049842
✓ MS21083N6 298+	Nut	1 Ea (1 ea)	90-Start up Operation	5036359
NAS1149F0632P 262+	Washer	2 Ea (2 ea)	90-Start up Operation	FM134497

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	✓ 188-FPSS-1032-1/4	2	21	0
	✓ 188-FSCS-832-5/8	4	100	0
	✓ 600.1309-A	1	0	0
	✓ 600.1313	1	6	0
	✓ AN4-16A	3	501	0
	✓ AN4-17A	1	683	0
	✓ AN6-15A	1	7	0
	✓ C2-14-2	2	200	0
	✓ C2-3-1	2	0	0
	✓ C2-3-2-1	2	0	0
	✓ C2-3-3-1	1	0	0
	✓ C2-3-5	2	0	0
	✓ C2-3-8	2	0	0
	✓ C3-10-2	1	0	0
	✓ C3-12-1	2	40	0
	✓ C3-12-6 (5100-0037-SPP)	2	0	0
	✓ C3-13-1 (06FDU04)	2	0	0
	✓ C3-13-5 (DENDOFF)	1	0	0
	✓ C3-3-4-1 (5100-0012-SPP)	4	0	0
	✓ C3-3-9	1	0	0
	✓ C3-4-1	2	0	0
	✓ C3-7-1	1	0	0
	✓ C3-7-2	2	0	0
	✓ C3-8-4	1	0	0
	✓ MS21044N4	4	31	0
	✓ MS21083N3	2	100	0
	✓ MS21083N6	1	30	0
	✓ MS35266-63	1	50	0
	✓ NAS1149F0332P	2	3,555	0
	✓ NAS1149F0363P	1	269	0
	✓ NAS1149F0463P	8	152	0
	✓ NAS1149F0632P	2	33	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							